

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013095**Date Inspected:** 05-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

**OBG # TRIAL ASSEMBLY YARD**

This QA Inspector randomly observed the following work in progress:

**Segment # 7EE-PP60**

This QA inspector observed, ZPMC qualified welding personnel identified as 066258 perform Shielded Metal Arc Welding (SMAW) for weld connecting Deck Panel to Edge Panel Hold Back Area Cross Beam side, weld joint identified as CA045-004; ZPMC CWI is identified as Mr. Zhang Qiang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P2214-TC-U4b-FCM-1

**Segment # 7CW****Repair Welding.**

This QA inspector observed, ZPMC qualified welding personnel identified as 045221 perform Shielded Metal Arc Welding (SMAW) for weld connecting Deck Panel to Edge Panel Cross Beam side, weld joint identified as CA038-004; The Critical Welding Repair Report (CWRR) was B-CWR1228. ZPMC QC is identified as Mr. Zhang Qiang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

with WPS-345-SMAW-2G (2F)-FCM-Repair-1

## Segment # 7BW

### Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 048659 perform Shielded Metal Arc Welding (SMAW) for weld connecting Deck Panel to Edge Panel E5 Location Cross Beam side. weld joint identified as SEG036-047; The Critical Welding Repair Report (CWRR) was B-CWR1325. ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1

## Segment # 7CW

### Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 054467 perform Shielded Metal Arc Welding (SMAW) for weld connecting Deck Panel to Edge Panel E2 Location Bike Path side, weld joint identified as CA040-002; The Critical Welding Repair Report (CWRR) was B-CWR1227. ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1. See the attached below photo.

## Segment # 7CW

### Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 048659 perform Shielded Metal Arc Welding (SMAW) for weld connecting Deck Panel to Edge Panel E5 Location Cross Beam side, weld joint identified as CA040-002; The Critical Welding Repair Report (CWRR) was B-CWR1210. ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. See the attached below photo.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Prabhune,Manoj	Quality Assurance Inspector
----------------------	----------------	-----------------------------

---

<b>Reviewed By:</b>	Miller,Mark	QA Reviewer
---------------------	-------------	-------------